

Date: Thursday, 04/09/2008 1:23:23 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: FITTING	
Job Number	: 41829		Part Number	: D32993	
Estimate Number	: 11396		Drawing Number	: D3299 REV B	
P.O. Number	:		Project Number	: N/A	
This Issue	: 04/09/2008 S.O. No. :		Drawing Revision	: B	
Prsht Rev.	: NC		Material	:	
First Issue	: / / Type : MACHINED PARTS		Due Date	: 30/09/2008 Qty: <i>20</i>	
Previous Run	: 40257			Um: Each	
Written By	:				
Checked & Approved By	: <i>JUL 08.9.04</i>				
Comment	: Est: A 04.10.04 New issue KJ/JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6H1000	6061-T6 HexBar 1.00	
		Comment: Qty.: 0.1925 f(s)/Unit Total : 2.3096 f(s) 6061-T6 1" HexBar Material: 6061-T6 (QQ-A-200/8 or QQ-A-225/8) 1.00" Hex (M6061T6H1.000) Identify as D3299-3 Batch: <i>M105238</i>	<i>mmf 08/09/15</i>
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
		Comment: Machine as per Folio FA452 and Dwg D3299 Deburr	<i>mmf 08/09/15 SA 08/09/16 (21)</i>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<i>mmf 08/09/15 SA 08/09/16 (21)</i>
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	<i>mmf 08/09/16 (21)</i>
5.0	OUTSIDE SERV.30	OUTSIDE SERVICES-MACH	
		Comment: Sub-Contracting OUTSIDE SERVICES Issue P/O: <i>7174</i> Anodize as per Dwg D3299 Possible Supplier: TNM Paint Material release note is required	<i>mmf 08/09/16 (21)</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: FITTING
Job Number: 41829		Part Number: D32993
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
6.0	PACKAGING 1 	PACKAGING RESOURCE #1 
<p>Comment: PACKAGING RESOURCE #1 Receive & Inspect for Transit Damage Ensure Material Release Note is attached</p> <p><i>LC 8/9/25 (21)</i></p>		
7.0	QC5 	INSPECT WORK TO CURRENT STEP  <i>S08/08/05 (420) 211</i>
8.0	PACKAGING 1 	PACKAGING RESOURCE #1  <i>8/9/25 211</i>
<p>Comment: PACKAGING RESOURCE #1 Identify with P/N and B/N using a permanent fine point marker, then Stock Location: 82</p> <p><i>8/9/25 SL</i></p>		
9.0	QC21 	FINAL INSPECTION/W/O RELEASE  <i>08/09/2008 08/09/2008</i>
Job Completion 		<i>MF 08-09-26</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	41829
Description: Fitting	Part Number:	D3299-3
Inspection Dwg: D3299	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

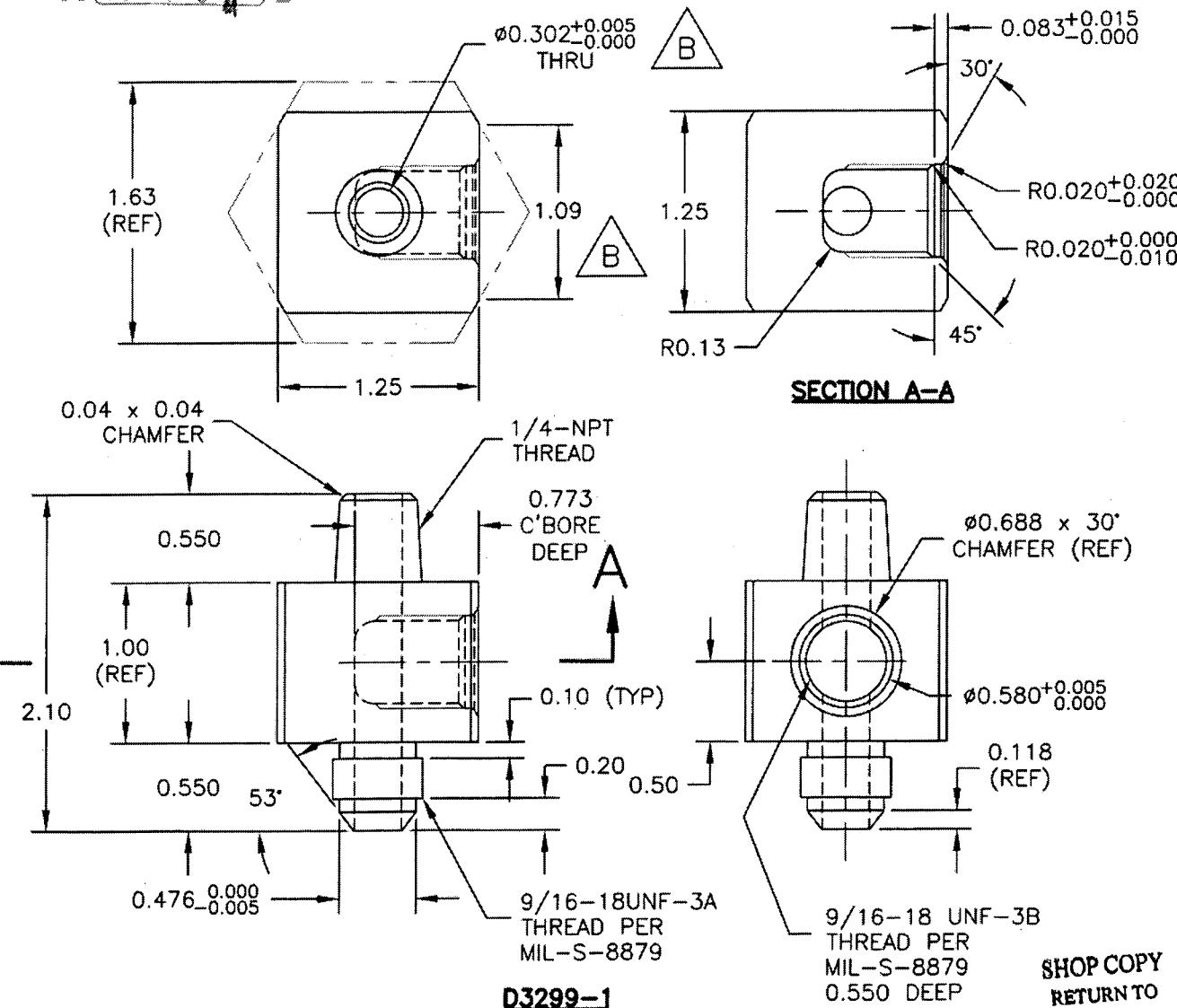
Measured by: <u>SD</u>	Audited by: <u>JL</u>	Prototype Approval: N/A
Date: <u>08/09/16</u>	Date: <u>08.09.16</u>	Date: N/A

Rev	Date	Change	Revised by	Approved
A	04.09.17	New Issue	KJ/JLM	
B	05.05.25	-0.005/+0.000 added to 0.476	KJ/JLM	
C	08.07.23	Dwg Rev updated	KJ/DD	 



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3299	SHEET 1 OF 3
DATE		TITLE	SCALE
05.04.28		FITTING	1:1
A	04.07.06	NEW ISSUE	
B	05.04.28	1.09 WAS 0.837; ϕ 0.302 WAS ϕ 0.297	

RELEASED
05.04.28



D3299-1 NOTES:

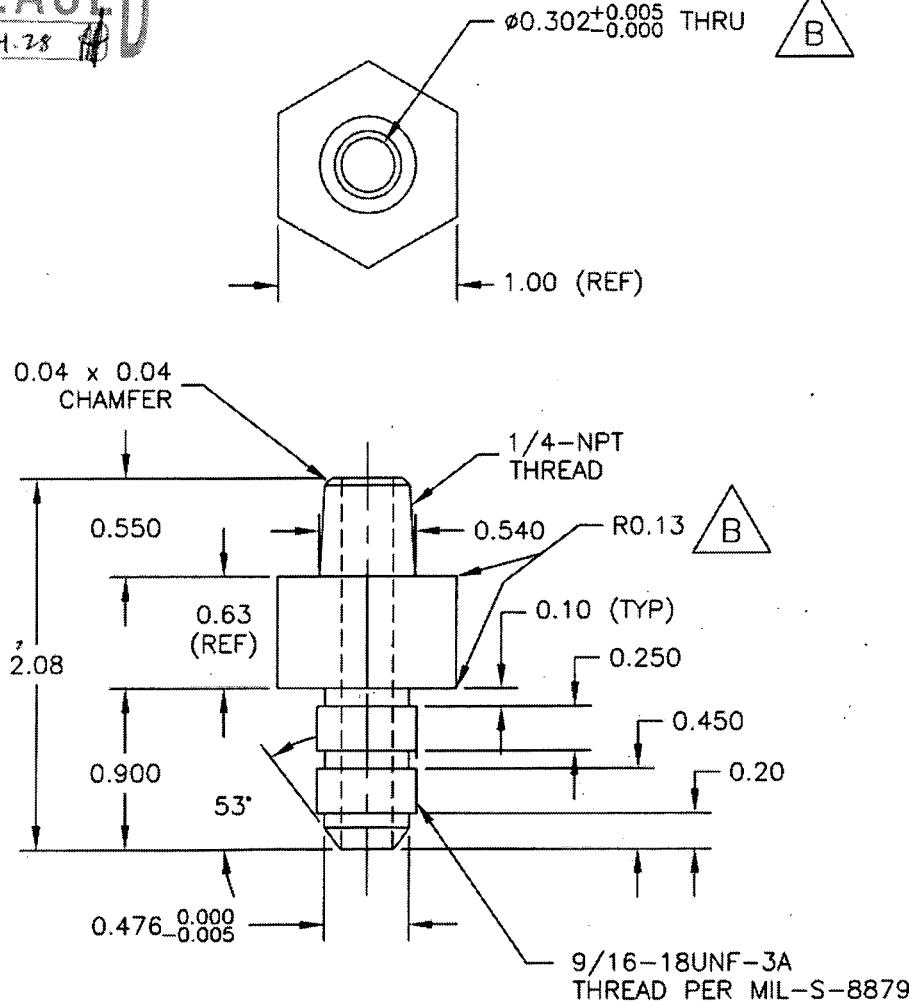
- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.63 HEX BAR (M6061T6H163)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 41829



DESIGN <i>P</i>	DRAWN BY <i>P</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3299	REV. B	SHEET 2 OF 3
DATE 05.04.28		TITLE FITTING	SCALE 1:1	

RELEASED
05.04.28



D3299-3

D3299-3 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.00 HEX BAR (M6061T6H1.00)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 5
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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WORK ORDER
NO. 41829

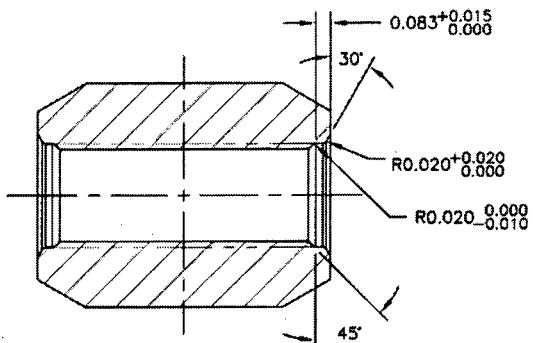
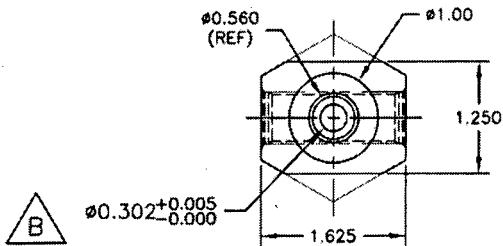
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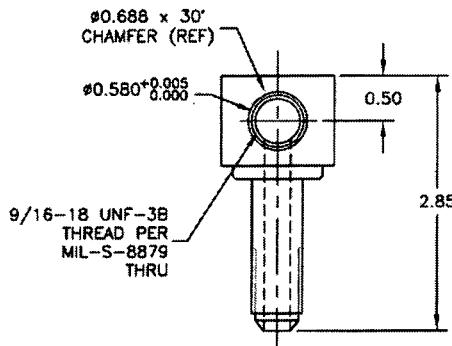
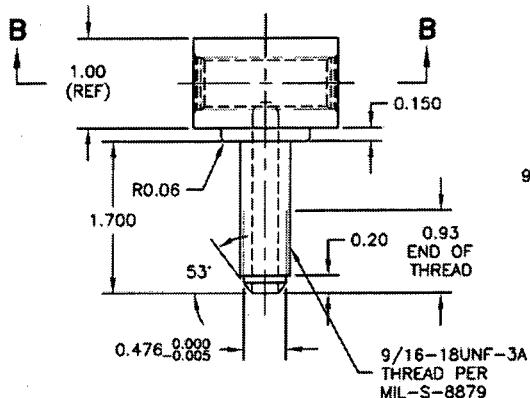


DESIGN <i>H</i>	DRAWN BY <i>H</i>	DART AEROSPACE LTD	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO.	REV. B
		D3299	SHEET 3 OF 3
DATE 05.04.28	TITLE FITTING	SCALE	1:2

RELEASED
05.04.28 *H*



SECTION B-B
SCALE 1:1



D3299-5

D3299-5 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.63 HEX BAR (M6061T6H1.625)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 certified

approuvé NADCAP approved

68350

23-Sep-2008

CLIENT / CUSTOMER:

DART AEROSPACE LTD.

1270 ABERDEEN STREET

HAWKESBURY , ONTARIO

K6A 1K7

CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITENO. DE COMMANDE: 7174
PURCHASE ORDER/

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	PART PROCESS & TREATMENT
1	110	110	D103-858-B	B41592 MATL: AL BLACK ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER
2	21	21	D3299-3	B41829 MATL: AL BLUE ANODIZE PER MIL-A-86251 TYPE II CLASS 2 ALL OVER

S
08/02/05

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.
Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.

Travel cards have been filled and are available for viewing upon request.

NOTE: Painted Parts will be Fully Solvent Resistant after 7 (seven) Full Days of Air Curing at Ambient Temperatures"

NOTE: Les pièces peintes seront complètement résistantes au solvant après 7 (sept) jours complets de séchage à l'air ambiant.

Signature/Signed:

Directeur de la Qualité / Q.A. Manager